

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001445**Date Inspected:** 01-Nov-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1330**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Zhang Lei & Li Wen Sheng (BV)			CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No N/A
				Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** 89 Mock-Up**Summary of Items Observed:**

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Item-1 89 Meter Mock-Up, Skin-B, MA24-1 to MP505, welds number 1, 3, 5 & 6. As stated by Zhenhua Port Machinery Company (ZPMC) Quality Control (QC) Inspector Li Yang Caltrans QA Inspector Mike Hasler did during first shift witness ZPMC Level II MT technician Cai Xin Xin perform an MT test on the welds listed above. This Caltrans QA Inspector did perform an MT test on selected areas of each of these welds and found them to be in compliance with the project specifications.

Item-2 89 Meter Mock-Up, Skin-C, Stiffener, weld 11. The welding of the cover pass was in progress and being performed by ZPMC welder Li Zhaoqian #048810 certified for Flux Core Arc Welding (FCAW) in the 3G position. The welding parameters recorded by this QA Inspector were, Amps 290, Volts 31.4, Travel Speed (T/S) 307 mm/min. and Temperature 148c.

Item-3 89 Meter Mock-Up, Skin-D, Stiffener, weld 3. Filler pass welding was being added by ZPMC welder Lei Lichao certified for FCAW in the 3G position. The welding parameters recorded by this QA Inspector were, Amps 309, Volts 31.8, T/S 317 mm/min. and the Temperature was 155c.

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Summary of Conversations:

There were no pertinent conversations pertaining to the project during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Smith,David

Quality Assurance Inspector

Reviewed By: Cochran,Jim

QA Reviewer